

Work Order ID 57916

April 20, 2010 10:03:15 AM



Page 1

Item ID: D3492-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 20/04/2010 Start Qty: 80.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-4-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA632 & Dwg D3492 ☒ Dwg Rev: C ☐ Folio
Rev: _____

SL 10/04/27

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/04/27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 10/04/28

80

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Plug Assembly

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	JY 10/04/28			80	Ø		
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M114207 Memo (Flat End Only) <input type="checkbox"/> START TIME: 7:00am <input type="checkbox"/> OVEN TEMPERATURE: 7:30am <input type="checkbox"/> FINISH TIME: 3:20pm	0.00 0.00	JY => 10/05/04			80	Ø		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				80		15/10-5-4	

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April 20, 2010 10:03:15 AM

Page 3

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Revision ID:

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Start Date: 20/04/2010 Start Qty: 80.00

Required Date: 29/04/2010 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-13</u> Memo	0.00 0.00				<u>180</u>	<u>0</u>		
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/05/04
BS 10-5-04
510

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 20, 2010 10:03:19 AM

Page 1

Work Order ID: 57916



Parent Item: D3492-043



Parent Item Name: Plug Assembly

Start Date: 20/04/2010

Required Date: 29/04/2010

Comments: IPP Rev: A 06.03.21 New Issue JLM
IPP Rev: B 06-08-28 As per Rev B JLM
IPP Rev: C 07-12-06 Rev C dwg DD verified by: EC
IPP Rev: D 08-05-07 add note to count qty DD verified by: JLM

Start Qty: 80.00

Required Qty: 80.00

M6061T6R0.750

Purchased

No

100

f

70.3800

5.2632



6061-T6 Round Bar .750"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT012

70.38

112041

30

112442

40.38

5.3 JL 10/04/27

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

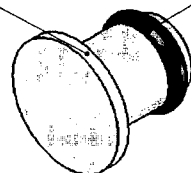
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 57916

10-4-20

UNDER REVIEW

08.11.12

DEO ATTACHED

RELEASED

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047: UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3492	REV. C
TITLE PLUG	SHEET 1 OF 2
	SCALE 2:1

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

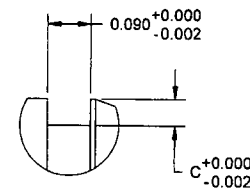
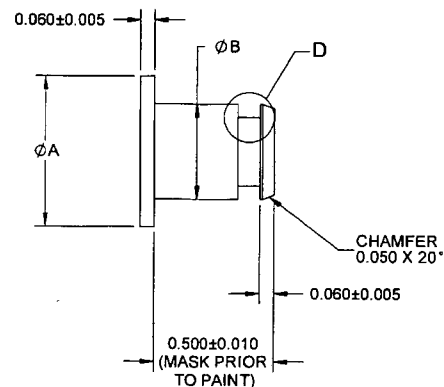
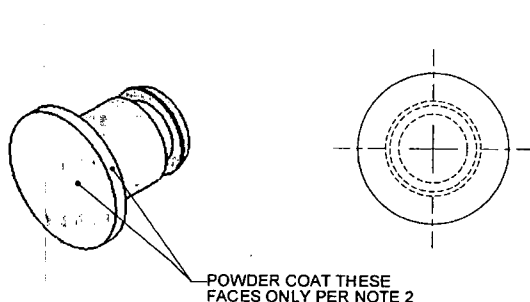
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

W/D 57914

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNDER REVIEW

03.04.11 RB
D3492-XX (HAWKESBURY)
ASS 08.11.12
OK

DEO ATTACHED

RELEASED
07.11.16

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		DRAWING NO. D3492
DATE	07.10.05	TITLE PLUG
		REV. C SHEET 2 OF 2 SCALE 4:1

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>EL</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

W/O 52914

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

RELEASED
08/11/10 MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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